

Date: Thursday, 20/11/2008 3:35:02 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: PLATE		
Job Number	: 43614					
Estimate Number	: 10499					
P.O. Number	:			Part Number	: D320411	
This Issue	20/11/2008	S.O. No.	:	Drawing Number	: D3204 REV.A1	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	11	Type	MACHINED PARTS	Drawing Revision	: A1	
Previous Run	: 35874			Material	:	
Written By	:				Due Date	: 21/12/2008
Checked & Approved By	: <u>Jul 08.11.21</u>			Qty:	4	Um: Each
Comment	: Est:C 05.08.11 Added Step 25 KJ/JLM			EsT Rev:D Now on Waterjet 08-01-08 JLM Verified By:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0375X01000	6061T6 BAR .375 x 1.00	
		Comment: Qty.: 0.1116 f(s)/Unit Total : 0.4465 f(s) Material: 6061-T6 .375" THK X 1.0" Batch: <u>107220</u> <u>BS 8-12-9</u>	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3204 Dwg Rev: <u>A1</u> <u>BS 8-12-9</u> Prog Rev: <u>A1</u>	
		2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		<u>BS 8-12-9</u>	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE 1-Face to size .300" 2-Open hole to .191" as per Dwg D3204 3-Deburr	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

5.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MF 08/12/17 (S)

6.0 QC8

SECOND CHECK



Comment: SECOND CHECK

JL 08/12/18

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

STN

PL 08/12/19 (G)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/22 (J)

Job Completion



MF 08-12-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	53014
Description: Plate	Part Number:	D3204-11
Inspection Dwg: D3204	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

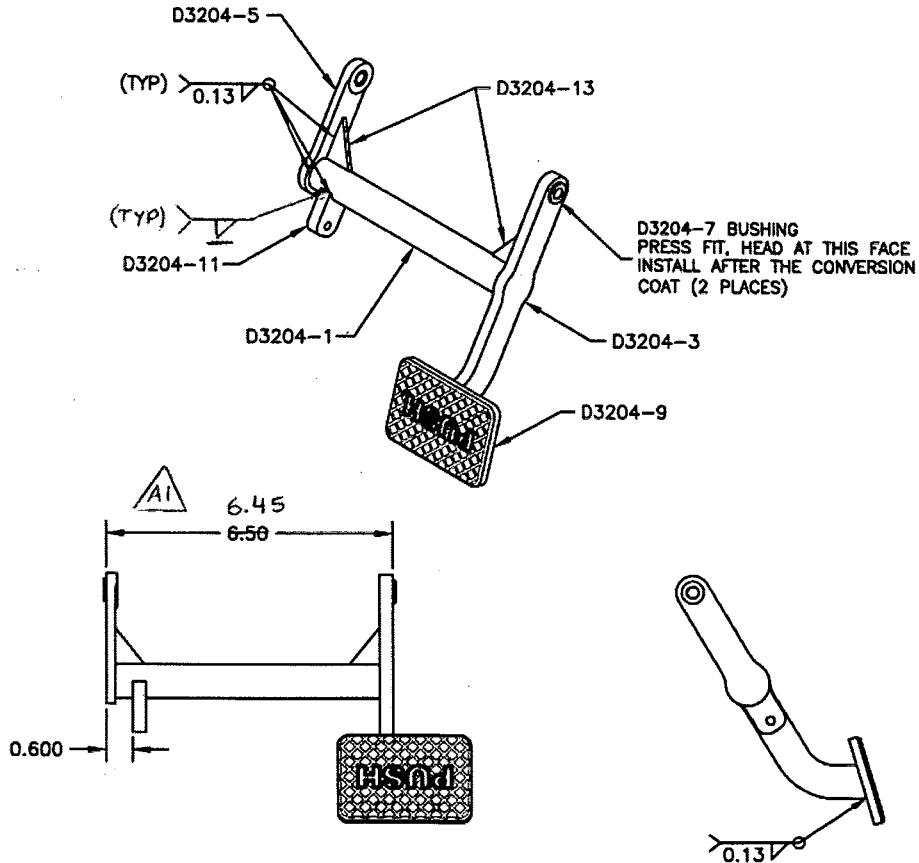
X First Article Prototype

Measured by:	IB	Audited by:	JL	Prototype Approval:	N/A
Date:	8-12-9	Date:	08/12/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	
B	06.03.21	Dwg Rev update	KJ/JLM	<i>[Signature]</i>

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	D3204	REV. A
DATE		TITLE	RELEASE PEDAL ASSEMBLY	SCALE NTS
04.01.27				

RELEASED
04.04.30**D3204-041 RELEASE PEDAL ASSEMBLY****NOTES**

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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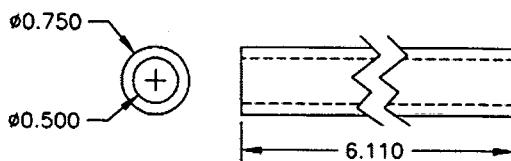
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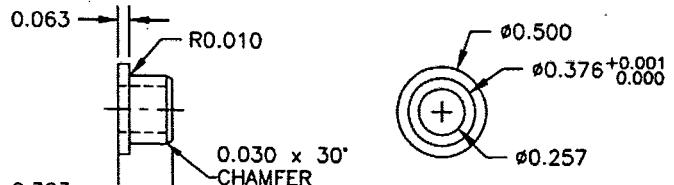
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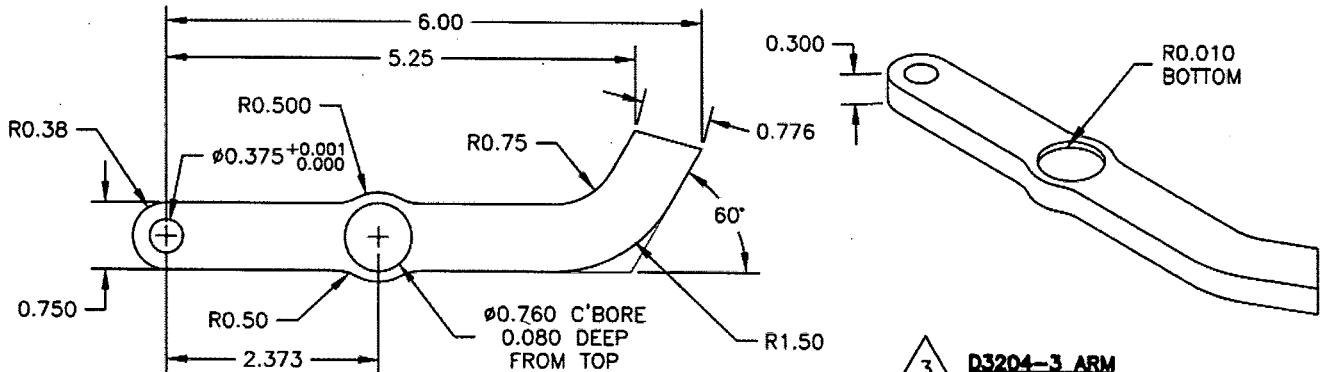
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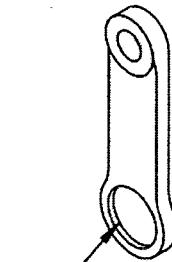
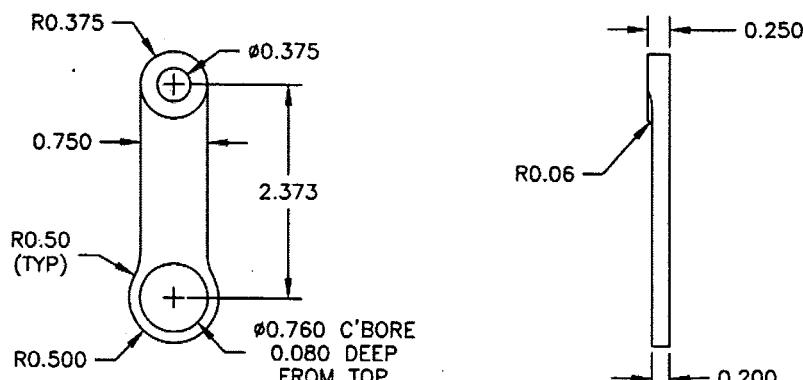
2 D3204-1 TUBE
SCALE 1:2



4 D3204-7 BUSHING
SCALE 1:1



3 D3204-3 ARM
SCALE 1:2



3 D3204-5 ARM
SCALE 1:2

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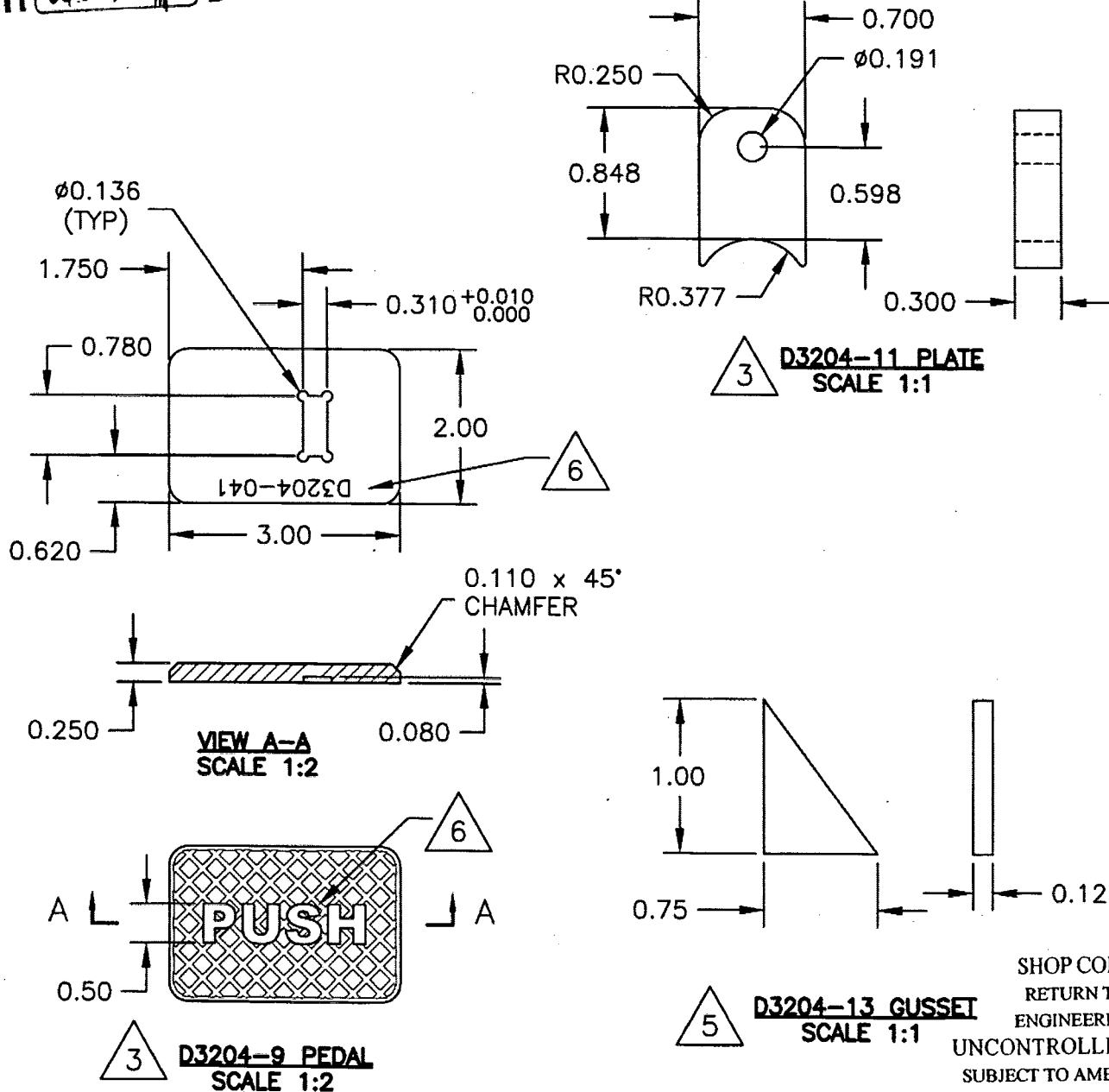
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DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

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4.04.30



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